

Date: Thursday, 22/01/2009 8:13:58 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSY WELDMENT
Job Number	: 45051		
Estimate Number	: 13418		
P.O. Number	:	Part Number	: PB674300107
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.5
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45049	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>MF 09-0122</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Base Assembly

batch:- B45027,4

Pl 09.04.17

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube

batch:- 345499 → 1 345259 → 2

(PB) →

Pl 09.04.17

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube

batch:- 345261

Pl 09.04.17

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Square Tubing

batch:- 3x 40596, 9x 44989

Pl 09.04.17

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)


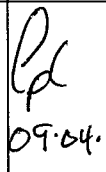

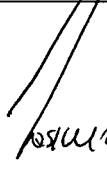
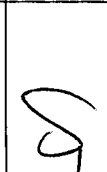

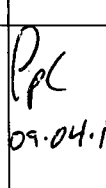


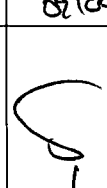
Square Tubing

batch:- 43073

Pl 09.04.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-07 PAR #: 09/01/11 Fault Category: Eng. / Draw NCR: Yes ☒ No ☐ DQA: D Date: 09/04/20  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 45051		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/16	#13	PB67-43001205 was cut @ the wrong angle. Doesnt align with PB67-4300147. <del>RC</del> was Done on w/o 45059.		SCRAP QTY (F) NO Replace	 09-04-17	 09/04/20		 09/04/20
		RC was mused at inspection and machined wrong.			 09-04-17	 09/04/20		 09/04/20

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 45051

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001201

Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tubing

batch:- 44990

*Ppl 09.04.17*

7.0

PB6743001203

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tube

batch:- 41907

*Ppl 09.04.17*

8.0

PB6743001207

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tube

batch:- 43199

*Ppl 09.04.17*

9.0

PB6743001219

Angled Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Angled Male Eye

batch:- 41908

*Ppl 09.04.17*

10.0

D34405

Contoured Detent Clip Base (Supersedes B



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Contoured Detent Clip Base

batch:- 41454

*Ppl 09.04.17*

11.0

D34407

Detent Clip Base (Supersedes B67-43001-2



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Detent Clip Base

batch:- 41455

*Ppl 09.04.17*

12.0

D344015

Contoured Male Eye (Supersedes B67-43001



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Contoured Male Eye

batch:- 41453

*Ppl 09.04.17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:13:58 AM  
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Job Number: 45051

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

\*\*\* ensure no burn thru after welding in tube -205 and -197 only where bushing -265 \*\*\*

*CP 09-04-17*

*(x2)*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*RF 09-04-20*

*(x2)*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/04/20*

*(x2)*

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*mask inside of D3440-5, D3440-7 and D3440-15 prior to paint\*\*\*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*M 18144*

*(2)*

START TIME:

*2:00*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*2:30*

*BR 09-04-20*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-04-20*

*(x2)*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *MISC*

*CP 09-04-20*

*(x2)*

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/22*

Job Completion



*RF 09-04-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

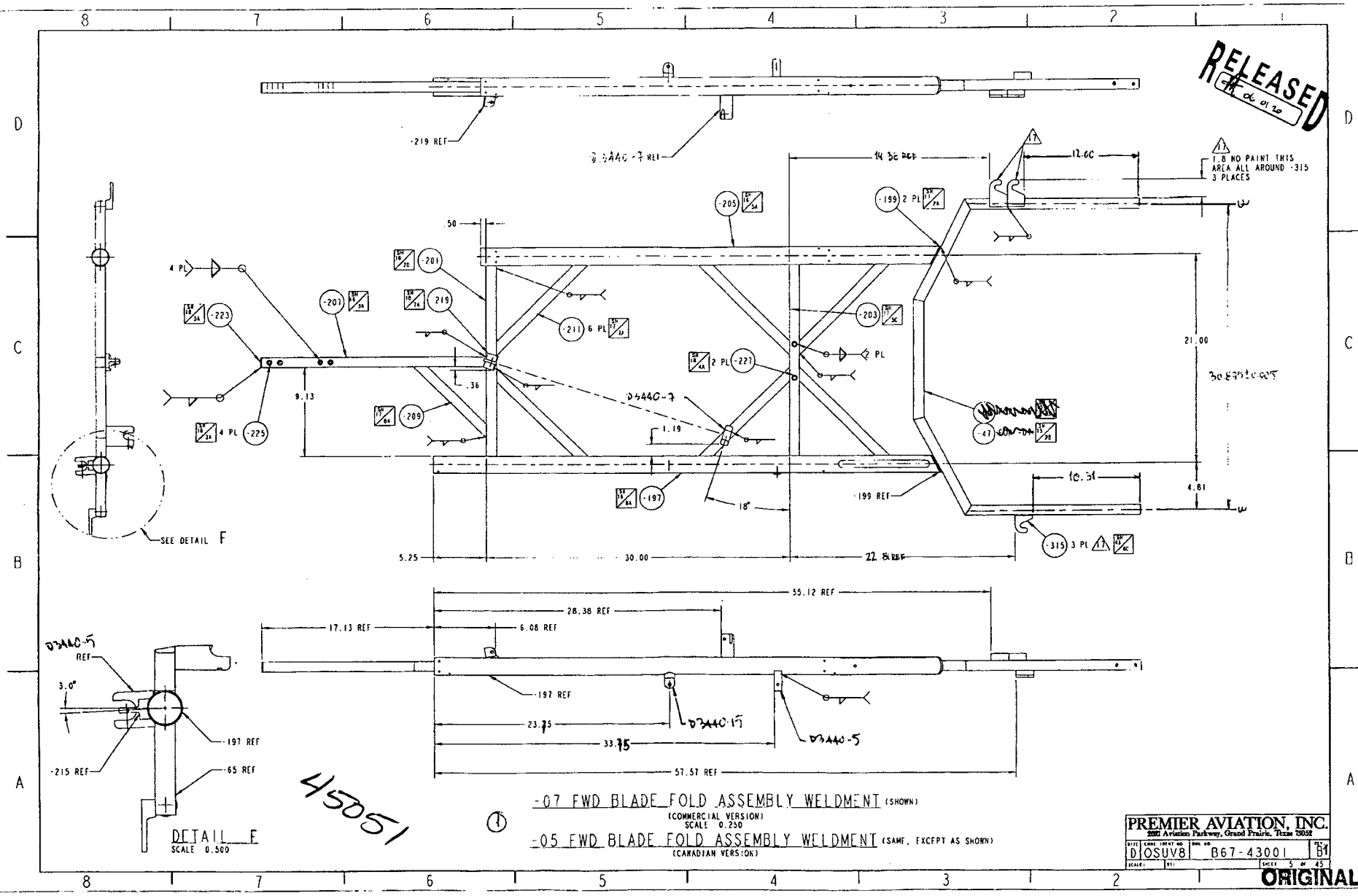
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

RELEASED  
17 DEC 01 20



-07 FWD BLADE FOLD ASSEMBLY WELDMENT (SHOWN)  
(COMMERCIAL VERSION)  
SCALE 0.250  
-05 FWD BLADE FOLD ASSEMBLY WELDMENT (SAME, EXCEPT AS SHOWN)  
(CANADIAN VERSION)

PREMIER AVIATION, INC.  
3000 Aviation Parkway, Grand Prairie, Texas 75050  
D105UV8 B67-43001 B1  
SCALE: 1"=1' 5"=45'

ORIGINAL